

Work Order ID 51727

August 31, 2009 10:12:40 AM

Page 1

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00

Required Date: 09/10/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 09-08-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

0.00

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

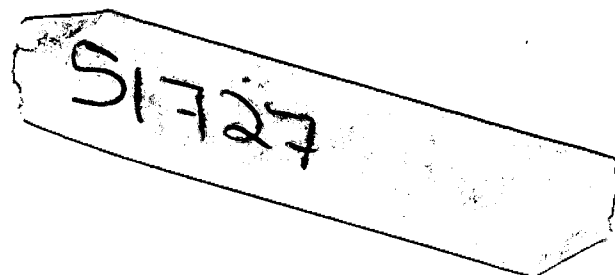
100

DC

Document Control

S 09/09/10

HJ for BG 09/09/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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August 31, 2009 10:12:40 AM



Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ Aluminum Rod

☐ mill 682

10-Grind welds flush as per Dwg D2750

9-8-31

MB

09-08-31

3 09-09-01

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

⇒ 8/31/09



130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8/31/09



140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

MB 09-09-07



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: ☐☐
exp. date: 10-02-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M11682

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

Handwritten notes and signatures:

- 9-9-3
- M112391 - AWM 9-9-3
- 10-02-20
- BE 9-9-4
- 9-9-4

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August 31, 2009 10:12:40 AM



Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

DP 9-9-4

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) 8 09/09/08

(X)

6

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 09/09/08

(X)

6

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Blk 09-09-8 D

W/O:		WORK ORDER CHANGES					
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August 31, 2009 10:12:40 AM



Page 7

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME: 11:45AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:45AM

0.00

Powder Coating

210

QC3- Inspect Part Finish

0.00



QC

Memo

Inspect for foreign object per QSI 024

0.00

Quality Control

220

HandFinishing

0.00



HandFinish

Memo

1- Install inserts as per Dwg D2750

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Page 8

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
	HandFinishing								
Hand Finish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>MA 6</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>m112391</u> EXP DATE: <u>10/20</u>								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>m101223</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>m104251</u>								
240									
	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

X1

MD 09/10/09

⇒ Sordalor

Ⓣ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 51727

August 31, 2009 10:12:40 AM



Page 9

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Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: / Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/10 (1)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

=> 50/10/10

(10) 0

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

Reo G

9/9/10 (10) 50

W/O:		WORK ORDER CHANGES					
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August 31, 2009 10:12:40 AM



Page 10

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/10

MF

09-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Page 1

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	54.0000	1.0000			
Cap												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

54

44892

19

47488

35

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000

Extrusion Bent

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000

Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

B 47133 DP 9-8-31

1 BE 09/09/01

8 BE 09/09/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
												
350 I Beam												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

AWM 9-9-3 (3)

D3490-3RevA

Manufactured

No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

4 BE 9-9-4

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Parent Item Name: Skidtube LH



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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA  Cross Bolt Spacer		Manufactured	No			160	Each	165.0000	4.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165
45338	2
47118	4
47657	50
48277	109

Handwritten: 4 BE 08/09/04

ALS4-1032-225  Insert		Purchased	No			220	Each	8,822.000	38.0000 			
--	--	-----------	----	--	--	-----	------	-----------	--	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8822
107441	16
110768	8806

Handwritten: X38 mnd 09/09/09

D3492-041RevC  Plug Assembly		Manufactured	No			230	Each	3.0000	8.0000 			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3
43816	3

Handwritten: X5 mnd 09/09/09

Handwritten: X3 mnd 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA Wearshoe		Manufactured	No			230	Each	22.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
47720	11	
50216	11	

X1 mo 09/09/09

AN8C35A

BOLT

Purchased	No			230	Each	167.0000	1.0000
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

X1 mo 09/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

August 31, 2009 10:12:40 AM

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
40551	1	
47537	4	
50231	13	

XI MD 09/09/09

D3488-041RevB  Blade Fitting Assembly, LH		Manufactured	No			230	Each	29.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
41853	1	
44530	8	
47348	20	

XI MD 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

August 31, 2009 10:12:40 AM

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA 		Manufactured	No			230	Each	27.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 27

46531 2

47440 2

47722 11

50240 12

X1 mo 09/09/09

AN6C44A



Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 2

103964 2

Main Warehouse

ST 170

110105 4

110155 14

110665 1

110865 51

111605 50

111649 50

X4 mo 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Page 7

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			230	Each	92.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

XI MO 09/08/09

D3536-25RevA

Manufactured No

230

Each

21.0000

1.0000




Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

XI MO 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

August 31, 2009 10:12:40 AM

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA 		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105

38139

6

45353

16

47437

83

X8 MD 09/09/09

D3791-1RevA



Manufactured No

230

Each

18.0000

1.0000

Wearplate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

X1 MD 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Page 9

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,846.000	38.0000			

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2746

112116

2746

X38 mo 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB  Bushing		Manufactured	No			230	Each	272.0000	8.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
<u>45556</u>	69
46695	18
48278	110

18 mo 09/09/09

AN3C5A Purchased

No

230

Each

650.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	650
111424	8
<u>111707</u>	342
112314	200
112489	100

342 mo 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

August 31, 2009 10:12:40 AM

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC  Wearpad		Manufactured	No			230	Each	46.0000	3.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 46

48288 3

50321 43

AN960C816L

Purchased

No

230

Each

330.0000

1.0000


WASHER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 330

104093 2

107520 4

110139 29

110372 36

110584 100

111424 159

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000


Plug Assembly

46407

x8

mb 09/09/09

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	1,060.000	4.0000			


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1060	
110372	84	
111982	976	

14 MO 09/09/09

NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	1.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

18 MO 09/09/09

NAS1611-010  O-RING		Purchased	No			230	Each	345.0000	1.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	345	
110715	50	
110915	295	

140

August 31, 2009 10:12:40 AM

Shop Packet Print

W/O: 51727		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/09	#230	Replaced NPS1611-010 for D2594-3 Batch #2 29908 (X8)	MD	09/09/09			C 09/09/10

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

August 31, 2009 10:12:40 AM

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB  Wearshoe		Manufactured	No			230	Each	11.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

47523

11

D3794-1RevA

Manufactured

No

230

Each

7.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

46530

1

47212

2

47121

4

MS21043-6

Purchased

No

230

Each

1,132.000

4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 08/31/2009

Required Date: 09/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000

✓



Washer

PC 9/8/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

44902

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

✓



NUT

PC 9/8/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

1112243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Page 15

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000	✓		09/9/10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

S AN960C816L



WASHER

Purchased

No

260

Each

330.0000

2.0000



1111684

09/9/10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Page 16

Work Order ID: 51727

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L  WASHER		Purchased	No			260	Each	350.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

D2741RevC

Manufactured

No

260

Each

40.0000

1.0000

Blade, 350 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

PHO →

84 09/09/10 (XU)

09/09/10 (1)

47113

August 31, 2009 10:12:40 AM

Shop Packet Print

Page 16

W/O: 51727		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/09	260	Route seq ID should be 230 instead of 260	MO	09/09/09			09/09/09

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 10:12:40 AM

Work Order ID: 51727



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D3532-1RevA Spacer		Manufactured	No			260	Each	43.0000	2.0000 ✓		08/31/10 (1)	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 43

38161 2

44904 41

S NAS1515H8L WASHER		Purchased	No			260	Each	129.0000	2.0000 ✓		08/31/10 (1)	
----------------------------	--	-----------	----	--	--	-----	------	----------	----------	--	--------------	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 129

107581 34

108964 1

111650 94

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

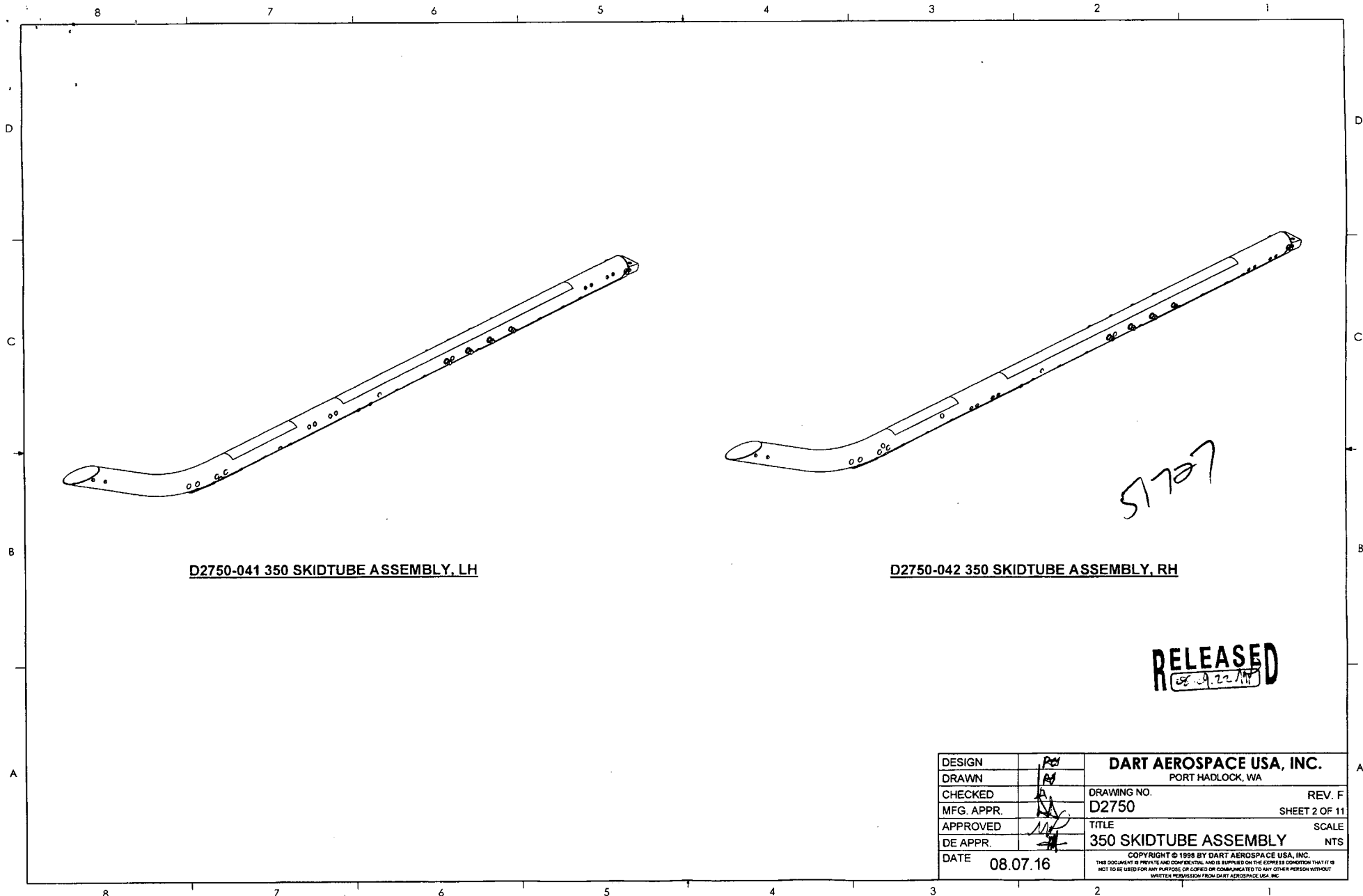
GENERAL NOTES:

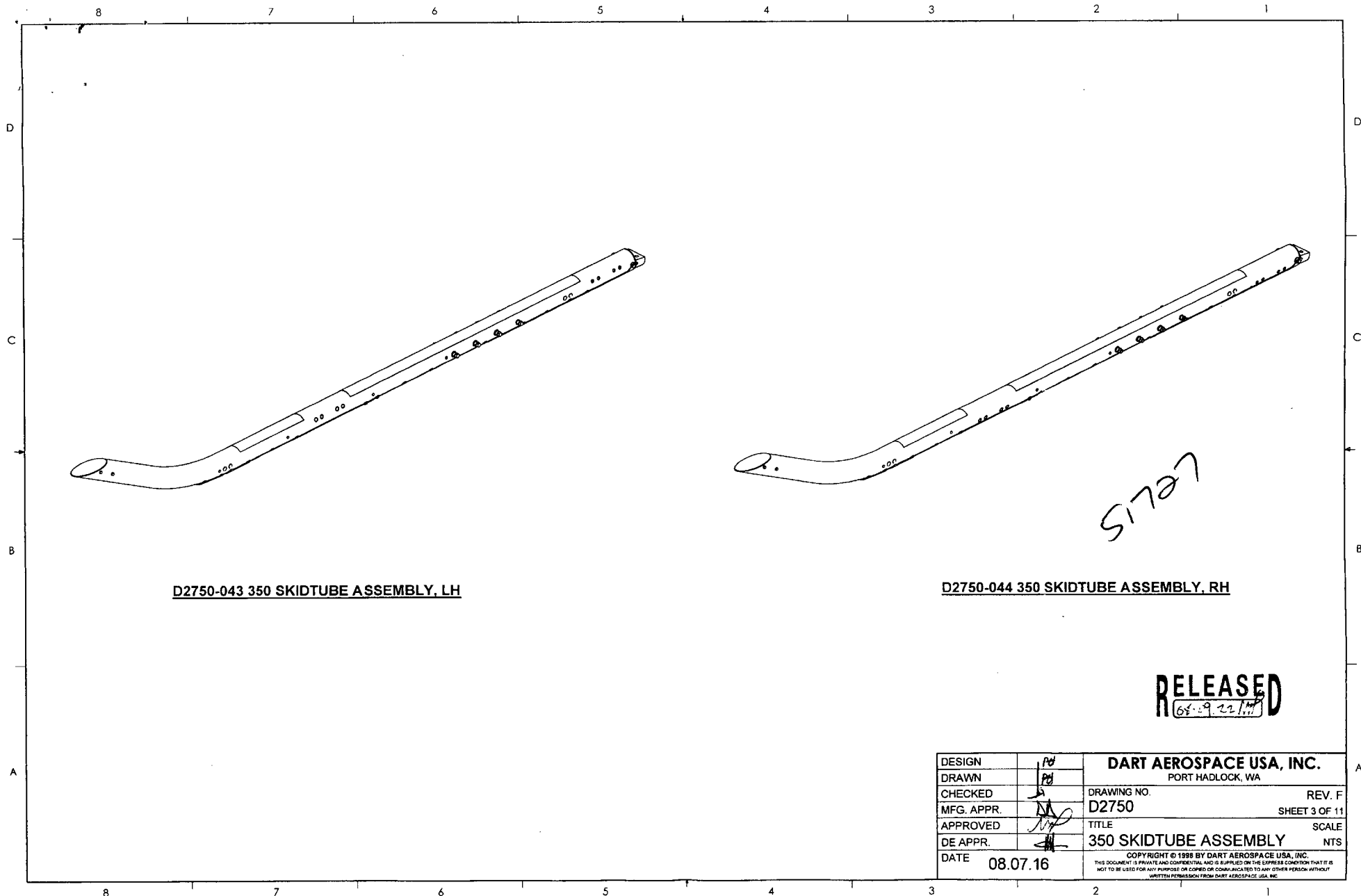
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

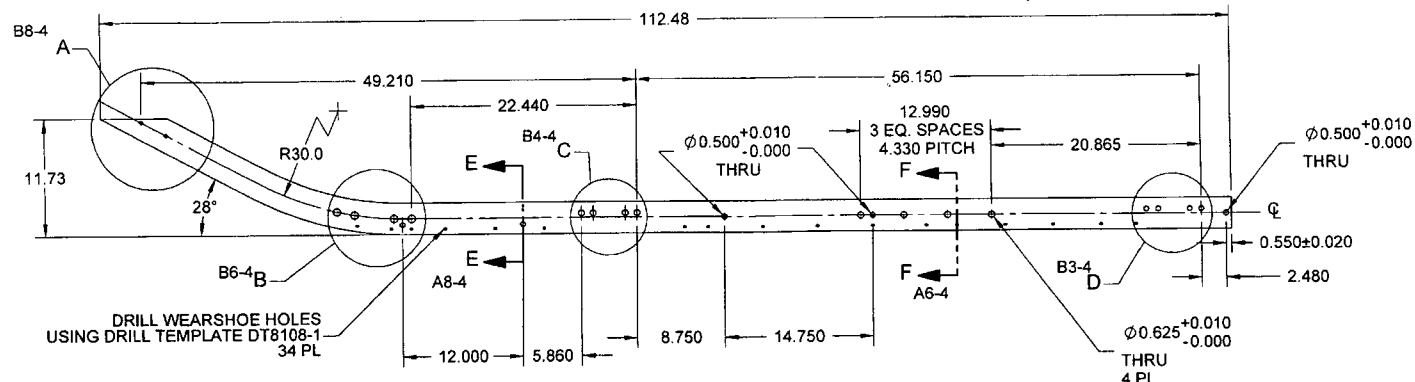
#51727.
Mf
09-06-31

RELEASED
68 09 22 14

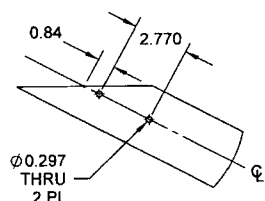
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO.	REV. F	
MFG. APPR.	D2750		SHEET 1 OF 11
APPROVED	TITLE	SCALE	
DE APPR.	350 SKIDTUBE ASSEMBLY	NTS	
DATE	08.07.16		
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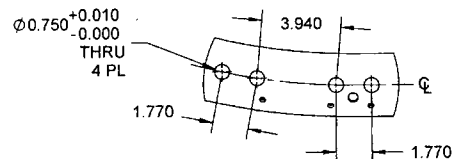




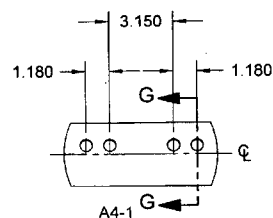
D2750-1 LH SKIDTUBE



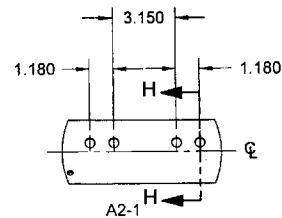
DETAIL A
SCALE 2X



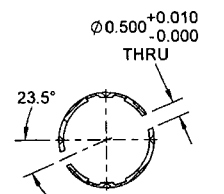
DETAIL B
SCALE 2X



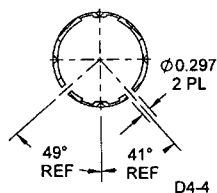
DETAIL C
SCALE 2X



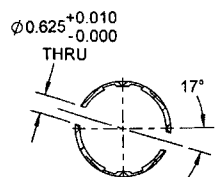
DETAIL D
SCALE 2X



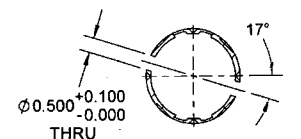
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



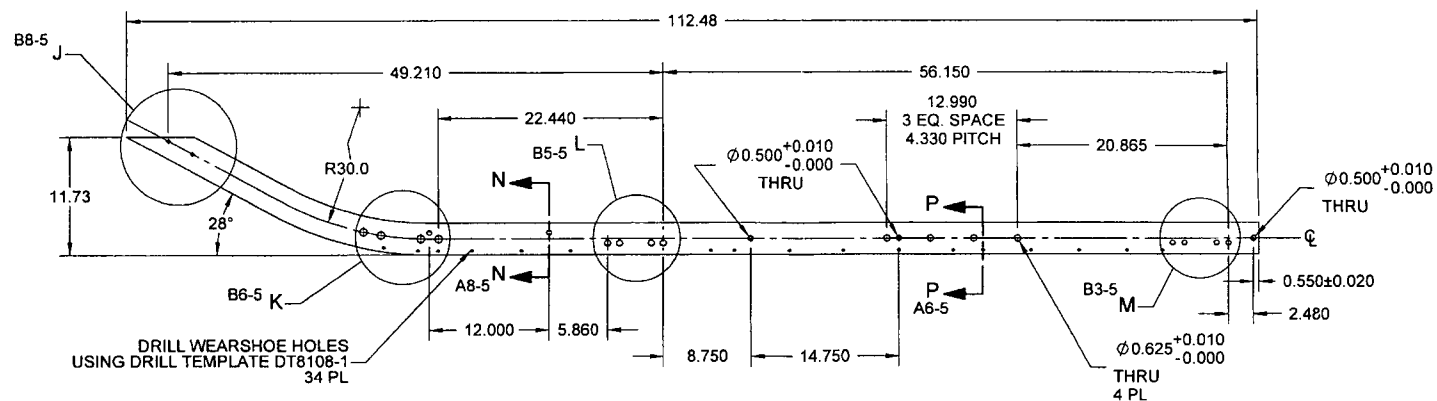
SECTION H-H
SCALE 3X, 4 PL

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

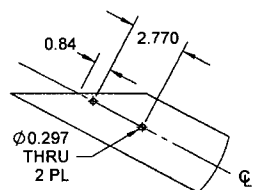
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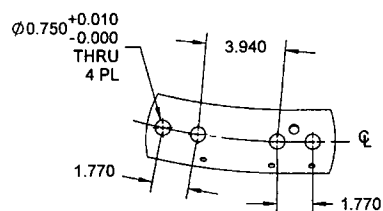
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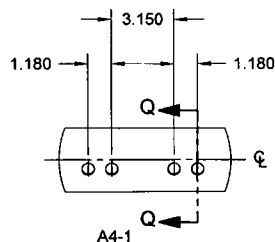
D2750-2 RH SKIDTUBE



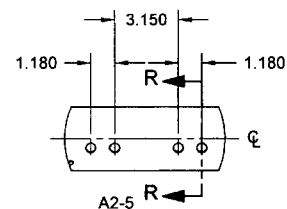
DETAIL J
SCALE 2X



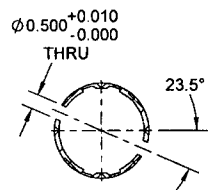
DETAIL K
SCALE 2X



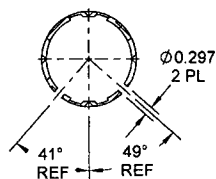
DETAIL L
SCALE 2X



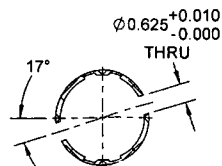
DETAIL M
SCALE 2X



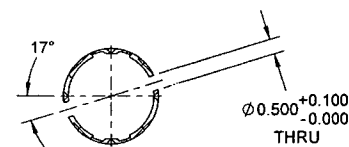
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

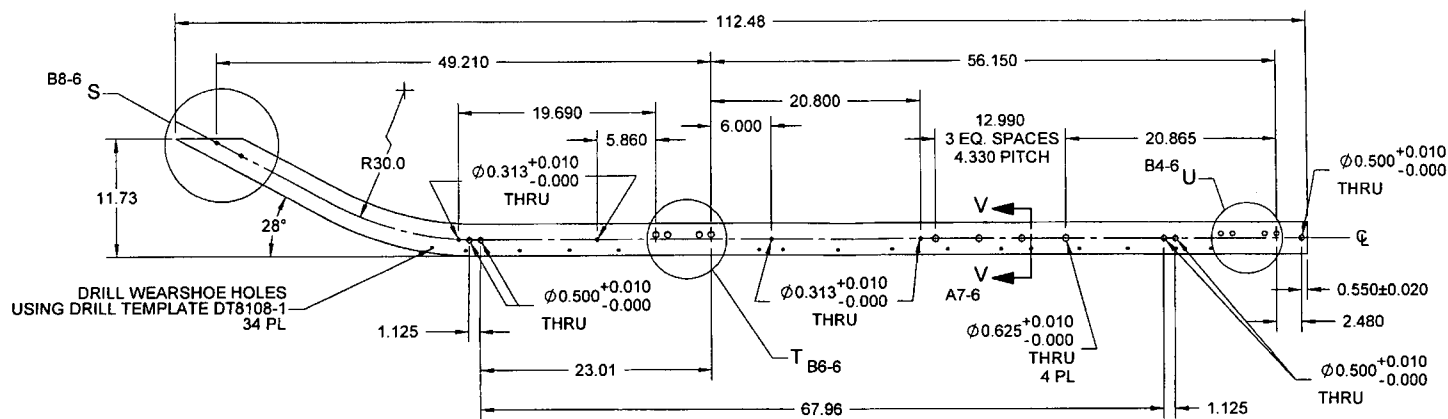


SECTION R-R
SCALE 3X, 4 PL

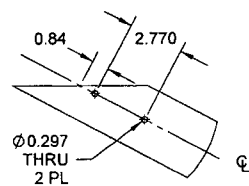
DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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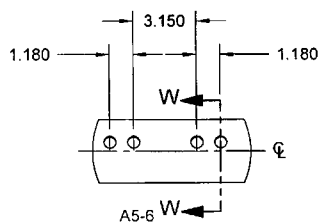
51727



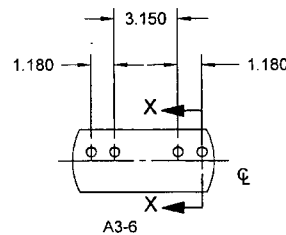
D2750-3 LH SKIDTUBE



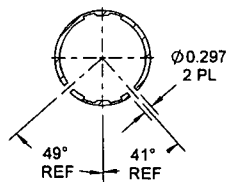
DETAIL S
SCALE 2X



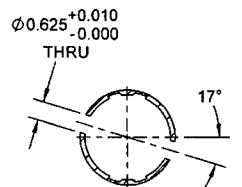
DETAIL T
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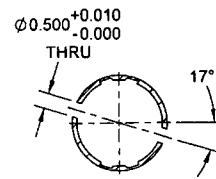
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



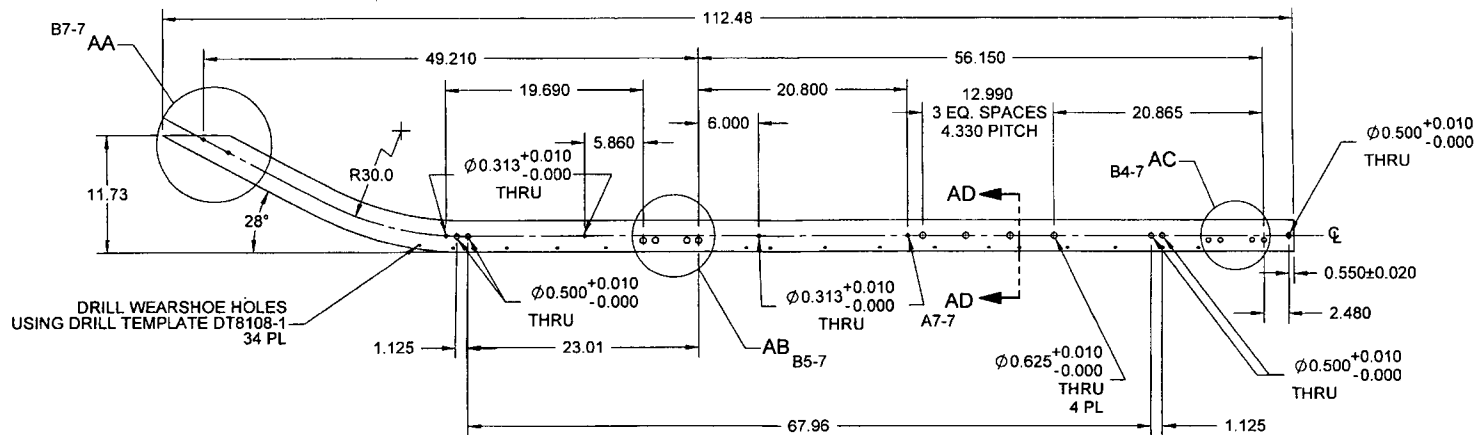
SECTION W-W
SCALE 3X, 4 PL



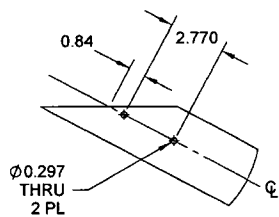
SECTION X-X
SCALE 3X, 4 PL

51727
RELEASED

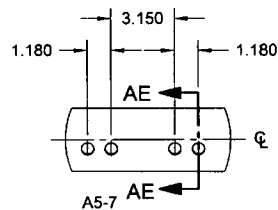
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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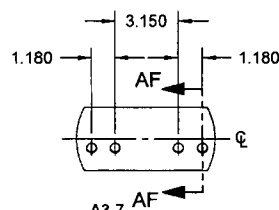
D2750-4 RH SKIDTUBE



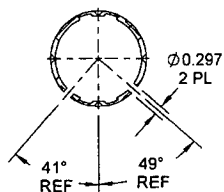
DETAIL AA
SCALE 2X



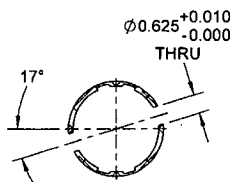
DETAIL AB
SCALE 2X



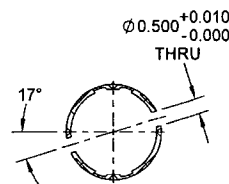
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

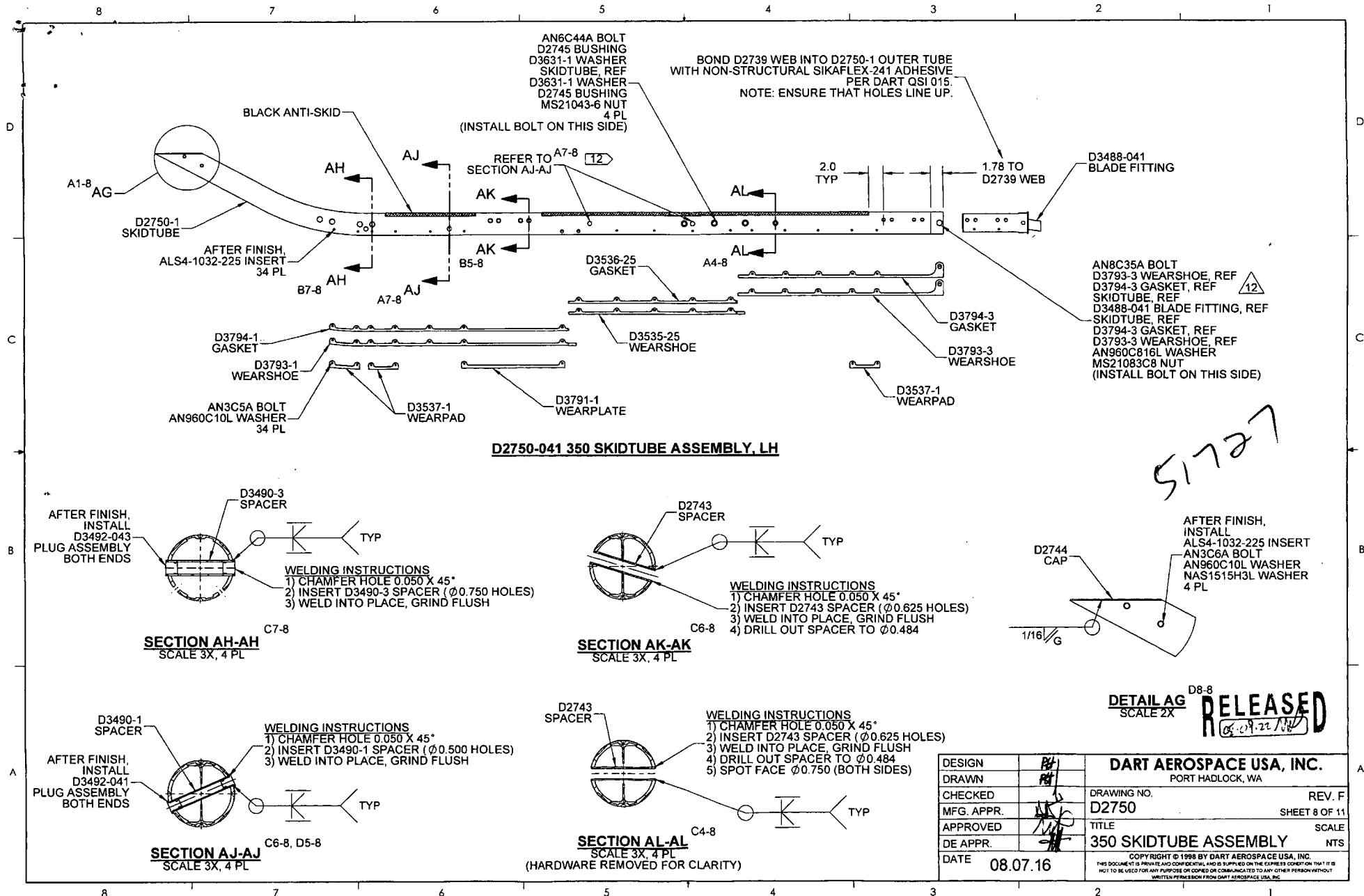


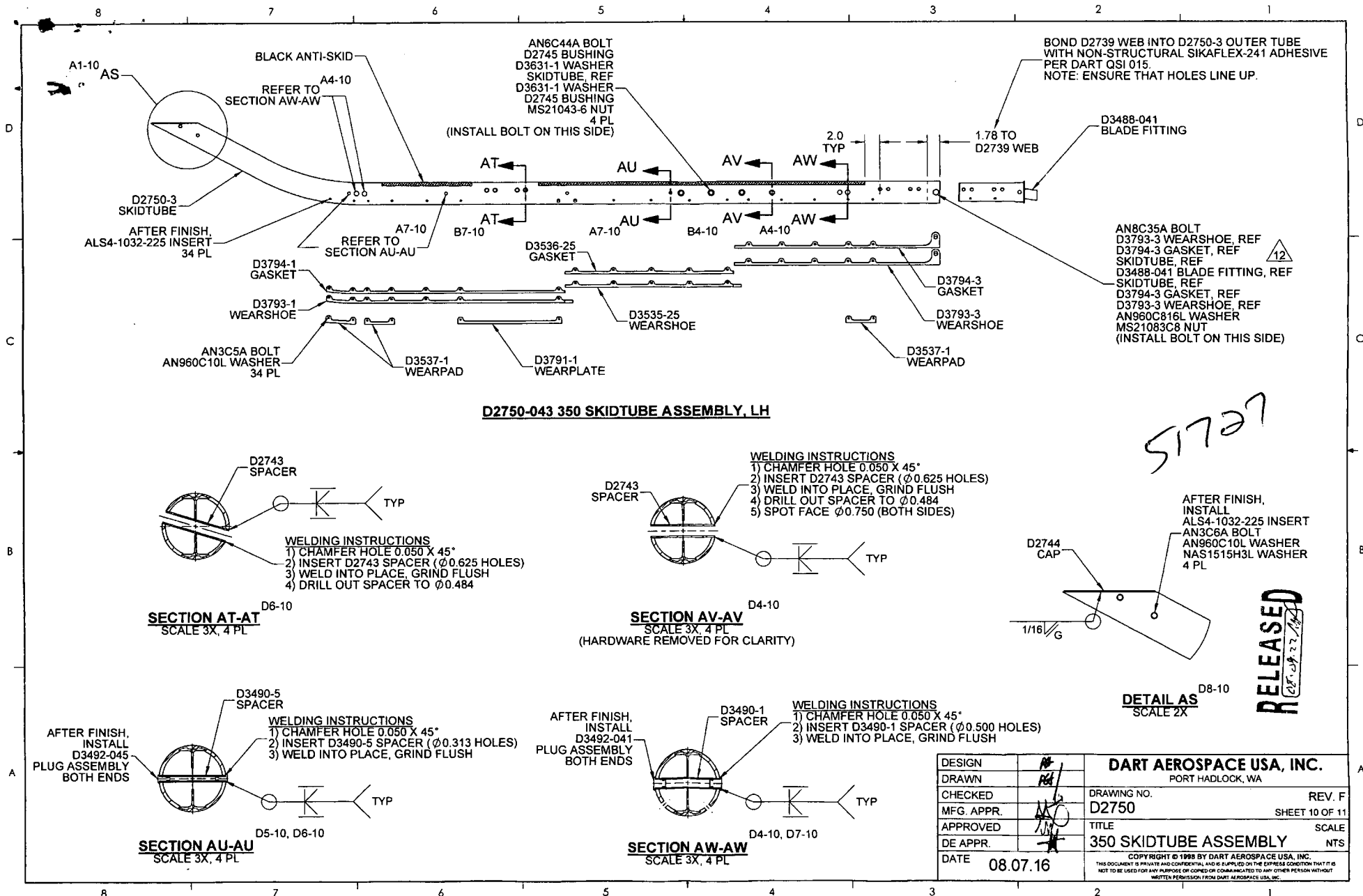
SECTION AF-AF
SCALE 3X, 4 PL

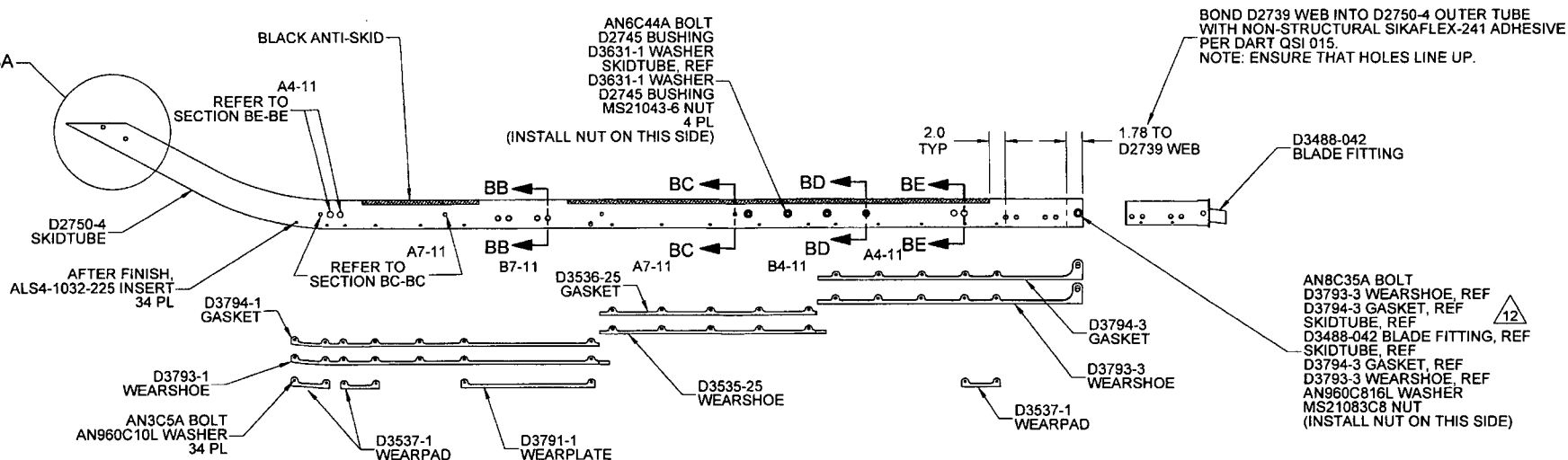
51727

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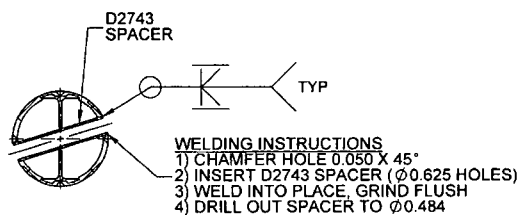
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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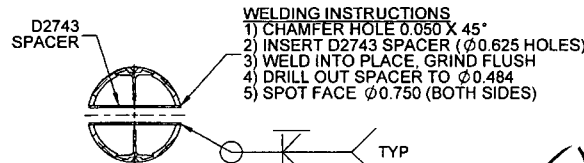




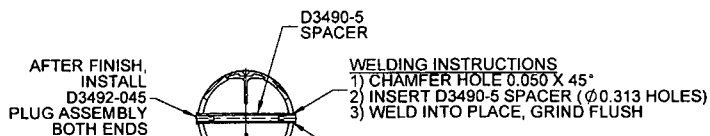
D2750-044 350 SKIDTUBE ASSEMBLY, RH



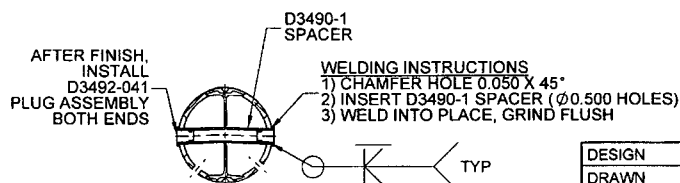
SECTION BB-BB
SCALE 3X, 4 PL



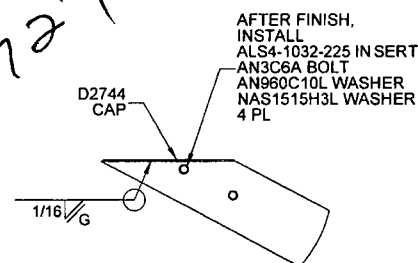
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED
08-07-22 / HP

51727

6.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRIUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRIUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
*11A	2	2	2	2		AN960C816L	WASHER
*11B	2	2	2	2		NAS1515H8L	WASHER
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

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Revision: F

Date: 08.08.14

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

51727

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Revision: F
Date: 08.08.14

NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 5011
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Del Date of Test Coupon 09.07.14
Welder Barclay Elliott Date of Test Coupon 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld